DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 82.28

WELDING INSPECTION REPORT

Resident Engineer: Casey, William
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-027072
Date Inspected: 19-Jan-2012

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: Westmont Industries

OSM Arrival Time: 600
OSM Departure Time: 1430
Location: Santa Fe Springs, CA

CWI Name:	Chris Concha			**CWI Present:**	☑ Yes	☐ No	
Inspected CWI report:	☐ Yes	☑ No	☐ N/A	**Rod Oven in Use:**	☑ Yes	☐ No	☐ N/A
Electrode to specification:	☑ Yes	☐ No	☐ N/A	**Weld Procedures Followed:**	☑ Yes	☐ No	☐ N/A
Qualified Welders:	☑ Yes	☐ No	☐ N/A	**Verified Joint Fit-up:**	☐ Yes	☑ No	☐ N/A
Approved Drawings:	☑ Yes	☐ No	☐ N/A	**Approved WPS:**	☑ Yes	☐ No	☐ N/A
				Delayed / Cancelled:	☐ Yes	☑ No	☐ N/A

Bridge No: 34-0006
Component: Maintenance Travelers

Summary of Items Observed:

On this date, Caltrans Quality Assurance Inspector (QA) Sherri Brannon is present at the Westmont Industries (WMI) jobsite in Santa Fe Springs, California for the purpose of observing fabrication and QC functions for the SAS Superstructure, Bid Item #99, Maintenance Traveler and Bid Item #100, Maintenance Traveler (Bike Path).

SAS-EB Traveler

This QA Inspector performed random shop observations and observed that Zemarc Corporation is on site at WMI today. Mr. Aquirre with Zemarc informed this QA Inspector that Zemarc will be here at WMI installing 2" compressed air line on the SAS-EB Traveler today. Zemarc completed installing the 2" piping on this date.

Elevating Platforms

This QA Inspector randomly observed WMI shop personnel Mr. Richard Fuentes WID #3201 and helper Mr. Jesus Rayas WID#3197, attaching grading to the steps on the SAS-EB, E2/E3-EB/WB Maintenance Travelers elevating platforms.

SAS Travelers Supplementary Access Platforms

This QA Inspector made random shop observations and was informed by (WMI) production fitter Mr. Larry Swanson (WID #3058) that welding on the SAS Travelers Supplementary Access Platforms is on hold pending RFI request to change the fit at hinge location. Per conversation with WMI Mrs. Ida Goldenberg WMI is in the process of submitting an RFI on the above.

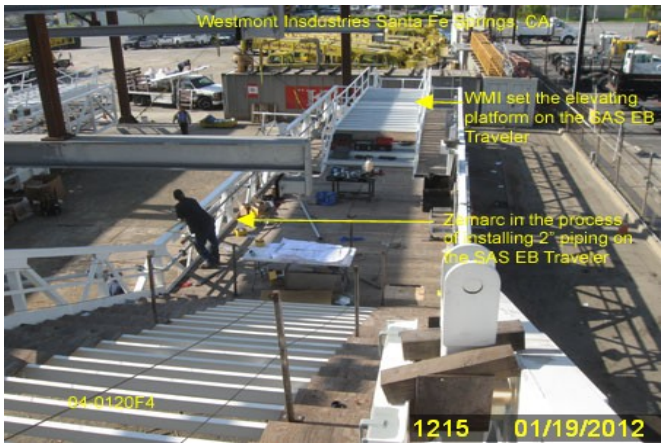
This QA Inspector randomly observed that Smith Emery, CWI, QC Inspector Mr. Chris Concha was present,

during the above mentioned welding and fitting activities. During random observation, this QA Inspector observed that the applicable WPS's and copies of the shop drawings, appeared to be located near each work station, where the above mentioned welding and fitting activities were being performed. This QA Inspector randomly verified that the consumable material, utilized during the welding appeared to be in compliance with the applicable WPS and that the above mentioned welders were currently qualified for the applicable process and position of welding. This QA Inspector randomly observed QC Inspector Mr. Concha verifying the in-process welding parameters, including voltage, amperage, pre-heat and travel speed and the parameters appeared to be in compliance to the applicable WPS.

RPI Coating (Blast and Paint)
This QA Inspector performed random shop observations and observed that RPI is on site to continuing with the coating application on the Maintenance Travelers. QA Inspector was informed by RPI Coating Mr. Manuel Barraza that RPI a will be abrasive blasting piping & swing arm brackets, and console and sump pump supports on the E2-E3 WB Maintenance Traveler today. RPI completed blasting and prime application of the above. Mr. Barraza informed this QA that PRI would be using Sherwin Williams Zinc Clad II Plus for the prime application. QA Inspector informed to Mr. Barraza that RPI will be proceeding at their own risk pending acceptance of the sample test results. Mr. Barraza stated that he is aware the RPI is proceeding at their own risk. After blasting was completed, QA Inspector then observed Mr. Barraza performing random surface profile checks on the blasted base metal surfaces. This QA Inspector observed Mr. Barraza utilizing a Testex Press-O-Film and a micrometer to perform the testing. During observation, this QA Inspector observed that the readings appeared to be 3.6 mils, and 3.4 mils. QA Inspector then observed Mr. Barraza perform a test for soluble salts on the previously blasted base metal surface. Testing observed by QA Inspector appears to be in compliance with the contract requirements.

This QA Inspector performed a DFT (dry film thickness) survey of the SAS EB and the E2/E3 EB piping, swing arms, console and sump support brackets on the Sherwin Williams, Zinc Clad II Plus prime coating application. The Sherwin Williams, Zinc Clad II Plus had been brushed and roll applied by RPI Coating. A total of eight measurements were taken randomly throughout the structure in accordance with SSPC PA2 criteria. The overall average was in compliance with the contract requirements of 90 microns to 150 microns. The prime coating was found to be well cured and to generally meet the contract requirements.

This QA noted above items observed appear to comply with contract documents.



WELDING INSPECTION REPORT

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Summary of Conversations:

As stated within this report.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy (510) 385-5910 , who represents the Office of Structural Materials for your project.

Inspected By:	Brannon,Sherri	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer